DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-030034
Date Inspected: 16-Sep-2013

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Job Site

CWI Name: Salvador Merino

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS Upper Saddle

Summary of Items Observed:

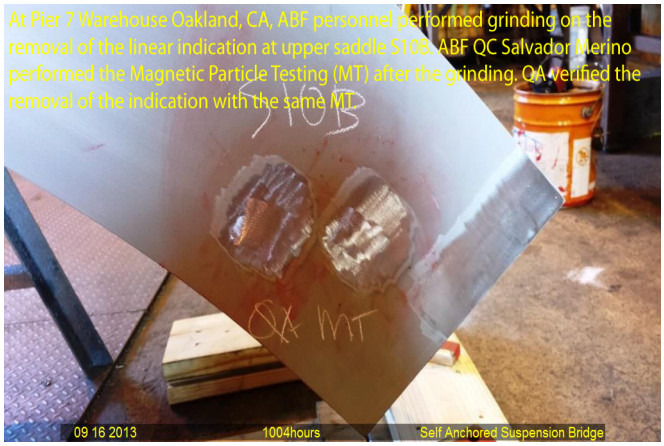
Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At Pier 7 Warehouse Oakland, CA this QA randomly observed ABF welders Richard Garcia and Rick Choinard perform Shielded Metal Arc Welding (SMAW) fillet welding between the 6 ½”/5” long x 2” wide x ¾” thick splice lugs to ¾” thick upper saddle S10B. The welders were using 3/32” diameter E7018H4R electrode during tack welding and switched to 1/8” diameter E7018H4R during the fillet welding implementing Caltrans approved ABF-WPS-D15-F1200A. The fillet welding of the splice lugs to the upper saddle is being done per Contract Change Order CCO #327. Prior tack and fillet welding, the welders were noted grinding off the paint then tack welded all eight (8) splice lugs. After tacking the splice lugs, the welders preheated the plates using propylene gas torch then performed the fillet welding. ABF personnel have tack welded two (2) 6 ½” long x 2” wide x ¾” thick and two (2) 5” long x 2” wide x ¾” thick splice lugs on each end of the upper saddle. During the shift, ABF QC Salvador Merino was noted on site monitoring the workmanship and parameters of the welders. All eight (8) splice lugs were completely fillet (1/4”) welded during the shift and ABF QC Salvador Merino also performed the visual/dimensional inspection on welded splice lugs. This QA also performed visual/dimensional verification on completely welded fillet on splice lugs and deemed in compliance to the project requirements.

After the welding completion of the eight splice lugs, the welders laid out the location of the grout clamping assembly four (4) outboard lugs also to be welded to the outboard side of the upper saddle. The welder has ground off the paint then tack welded the outboard lugs. The welder was able to tack weld all four (4) lugs before the shift

was over.

This QA performed Magnetic Particle Testing (MT) on the removal of the linear indication that was previously noted by the fabricator. ABF personnel ground removed the indications using a flapper disc grinder. Prior QA MT, ABF QC Salvador Merino performed the MT on the linear indication removal with no relevant indications noted during the test. This QA performed the MT verification and noted same result.



Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo,Joselito	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer